



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D4636-5
Job Sheet 185095



Part No: D4636-5

Job Qty: 40 ea

Part Name: Bracket



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 10/22/18

Job Tracking No:

Due Date: 11/9/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEET 4 IPP REV:A 12.04.30 NEW ISSUE DD VERF:EC IPP REV:C 13.07.17 AS PER DWG REV.C DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet	40 pcs	11/9/18	11/9/18	0.00	0.64	Waterjet 1		<i>SE 18/10/21</i>
120	QC	40 pcs	11/9/18	11/9/18	0.00	0.00	QC8		<i>38</i>
130	Small Fab	40 pcs	11/9/18	11/9/18	0.00	0.57	Small Fab		<i>3-89 DAS</i>
140	QC	40 pcs	11/9/18	11/9/18	0.00	0.00	QC5		<i>38</i>
150	HandFinish	40 pcs	11/9/18	11/9/18	0.00	0.42	HandFinish1		<i>D.B. 18/11/08</i>
160	QC	40 pcs	11/9/18	11/9/18	0.00	0.00	QC7		<i>BL 18-11-8</i>
170	Powdercoat	40 pcs	11/9/18	11/9/18	0.00	0.22	Powdercoat4		<i>BK 18-11-8</i>
180	QC	40 pcs	11/9/18	11/9/18	0.00	0.00	QC3		<i>DAS 38</i>
190	Packaging	40 pcs	11/9/18	11/9/18	0.00	0.00	Packaging3	<i>5/108</i>	<i>9-88</i>
200	QC21-SA	40 Ea	11/9/18	11/9/18	0.00	0.00	QC21		<i>NOV 13 2018</i>

M 138839 START 2/10 *O.T. 3000 FINISH: 2:40*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6S.040	6061-T6 .040 Sheet	.4000 sf (.01 ea)	100-Waterjet	<i>5120084</i>

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet	M6061T6S.040	0	292	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Bracket	0.129Inches + 0.005 - 0.001	0.134 0.128	<i>0,129</i> Diameter	
2	Bracket	0.221Inches + 0.006 - 0.001	0.227 0.220	<i>0,222</i> Diameter	
3	Bracket	0.200Inches ± 0.030	0.230 0.170	<i>0,202</i>	
4	Bracket	0.650Inches ± 0.010	0.660 0.640	<i>0,654</i>	
5	Bracket	1.300Inches ± 0.010	1.310 1.290	<i>1,303</i>	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																			
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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval _____																																																			
Description Work Order Deviation Part: D4636-5 Job No: 185095 Serial No/Batch: S122035 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 10/27/18 Container No: S122035 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com																																																							
Root Cause <table style="width:100%;"> <tr><td>Environment ☐</td><td>No Re-verification ☐</td><td>Pressure/Force ☐</td></tr> <tr><td>Design ☐</td><td>Operator ☐</td><td>Bending ☐</td></tr> <tr><td>Doc/Data ☐</td><td>Offset/Setup ☐</td><td>Centre Not Cor ☐</td></tr> <tr><td>Equip/Tooling ☐</td><td>Supplier ☐</td><td>Cracks ☐</td></tr> <tr><td>Handling/Pre ☐</td><td>Training ☐</td><td>Crimp/Kink/Rip ☐</td></tr> <tr><td>Material ☐</td><td>Use for Testing ☐</td><td>Cuffs ☐</td></tr> <tr><td>Internal Transport ☐</td><td>Poor Information ☐</td><td>Crushing ☐</td></tr> <tr><td>Tribal Knowledge ☐</td><td>Rushing ☐</td><td>Heat Treat ☐</td></tr> <tr><td>LOA ☐</td><td>Product Improvement ☐</td><td>Wave/Twist in Tube ☐</td></tr> <tr><td>Substation ☐</td><td>Process Improvement ☐</td><td>Marks/Chatter ☐</td></tr> <tr><td>Past Expiry Date ☐</td><td>Manufacturing Process ☐</td><td></td></tr> <tr><td>Misidentified ☐</td><td>Past Due ☐</td><td></td></tr> </table> FAULT CATEGORY <table style="width:100%;"> <tr><td>Contamination ☐</td><td>Out of Sequence ☐</td><td>Part Moved ☐</td></tr> <tr><td>Countersink ☐</td><td>Off-set ☐</td><td>Drawing ☐</td></tr> <tr><td>Cut Too Short ☐</td><td>Mislabeled ☐</td><td>Finish ☐</td></tr> <tr><td>Instructions Incomplete/Unclear ☐</td><td>Fit/Function ☐</td><td>Misread ☐</td></tr> <tr><td>Drill Holes ☐</td><td>Misaligned/off center ☐</td><td>Turning Sequence ☐</td></tr> </table>					Environment ☐	No Re-verification ☐	Pressure/Force ☐	Design ☐	Operator ☐	Bending ☐	Doc/Data ☐	Offset/Setup ☐	Centre Not Cor ☐	Equip/Tooling ☐	Supplier ☐	Cracks ☐	Handling/Pre ☐	Training ☐	Crimp/Kink/Rip ☐	Material ☐	Use for Testing ☐	Cuffs ☐	Internal Transport ☐	Poor Information ☐	Crushing ☐	Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Past Expiry Date ☐	Manufacturing Process ☐		Misidentified ☐	Past Due ☐		Contamination ☐	Out of Sequence ☐	Part Moved ☐	Countersink ☐	Off-set ☐	Drawing ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
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6	Bracket	1.700Inches ± 0.030	1.730 1.670	1,702
7	Bracket	0.900Inches ± 0.030	0.930 0.870	0,899
8	Bracket	0.040Inches ± 0.010	0.050 0.030	0,040

Plex 10/22/18 2:55 PM Dart.lajeunesse.marie

8 0 11

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WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY			
Environment ☐		No Re-verification ☐		Pressure/Forced ☐		Temperature/Cure ☐	
Design ☐		Operator ☐		Bending ☐		Set-up ☐	
Doc/Data ☐		Offset/Setup ☐		Centre Not Concentric ☐		BOM/Route ☐	
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